

Work Order ID 103228

June-19-13 10:09:07 AM

shp 21 June 13

103228

Page 1

Item ID: D4712-3

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Bracket

Stop *NS2*

Start Date: 6/19/13

Start Qty: 2.00

2

Cust Item ID:

Required Date: 7/03/13

Req'd Qty: 2.00

2

Customer:

Reference:

Approvals:

Process Plan: MLJ

Date: 13-06-19 Tooling:

Date:

Run Start *NR1*

QC:

Date: SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D4712

A

100

0.00

100

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg

Dwg Rev: A

Prog Rev: A

2-Deburr if necessary

8 0 JmB-619

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

8 0 JmB-619

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Page 2

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Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00				(42)			
130 *130* Brake NC Brake NC	Bend as per dwg NC BRAKE Memo C'sink holes as per dwg	0.00 0.00				(8)			8/13/19 13/06/20
140 *140* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				8			

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Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Chemical Conversion Coat per QSI005 4.1	0.00							
150									
HandFinish	Memo	0.00							
Hand Finishing									
160	QC7-Inspect Chemical Conversion Coat	0.00							
160									
QC	Memo	0.00							
Quality Control									
170	Receive & Inspect for Damage & Mat'l Certs	0.00							
170									
Packaging	Memo ID + sth	0.00							
Packaging	(Sylvie)								

G-A
w/p 103228

8x 13/06/20

8x 13-6-20

8x 13/06/20

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2

Cust Item ID:

Required Date: 7/03/13 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.00							
Quality Control									

MLS 13-06-21

13-06-20

Picklist Print

June-19-13 10:09:10 AM

Page 1

Work Order ID: 103228

103228

Parent Item: D4712-3

D4712-3

Parent Item Name: Bracket

Start Date: 6/19/13

Required Date: 7/03/13

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A 12.11.08 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M6061T6S.050

Purchased

No

100

sf

506.9120

0.182

~~0.383~~ 158

M6061T6S 050

**

1.0

JUN 13-6-19

6061-T6 .050 Sheet

Location

Loc Qty

Loc Code

MAT021

506.912

114799

56.682

114993

27

121192

102.4

123293

176.83

125636

144

125636

DART AEROSPACE LTD		Work Order:	103228
Description: Bracket		Part Number:	04712-3
Inspection Dwg: 04712 Rev: A		Page 1 of 1	

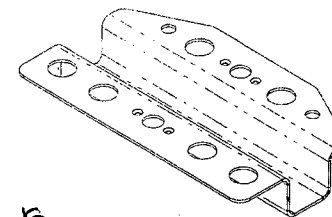
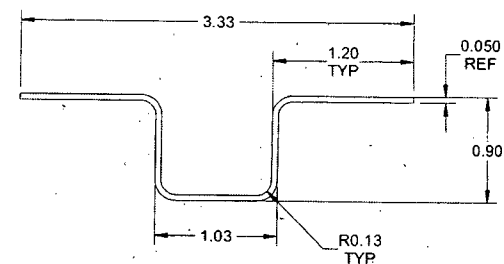
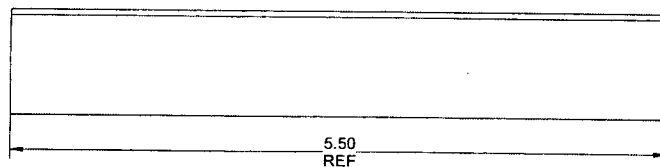
FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø 0.098"	+0.004-0.001	0.100"	-		✓	JLmw
Ø 0.250"	+0.005-0.001	0.253"	-		✓	
Ø 0.500"	+0.006-0.001	0.503"	-		✓	
Ø 0.380"	+0.005-0.001	0.381"	-		✓	
3.50"	+/-0.030"	3.501"	-		✓	
2.00"	"	2.002"	-		✓	
2.50"	"	2.50"	-		✓	
1.00"	"	1.006"	-		✓	
1.75"	"	1.754"	-		✓	
1.50"	"	1.50"	-		✓	
4.73"	"	4.732"	-		✓	
4.13"	"	4.134"	-		✓	
4.02"	"	4.02"	-		✓	
0.63"	"	0.630"	-		✓	
2.75"	"	2.749"	-		✓	
0.375"	+/-0.010"	0.376"	-		✓	
0.750"	"	0.754"	-		✓	
1.00"	+/-0.030	1.003"	-		✓	
0.55"	"	0.549"	-		✓	
3.40"	"	3.402"	-		✓	
4.40"	"	4.401"	-		✓	
5.50"	"	5.500"	-		✓	
0.050"	+/-0.010"	0.043"	-		✓	

Grain Direction		N/A			
Measured by:	Jm	Audited by:	Bas	Preliminary Approval:	
Date:	13-6-19	Date:	16/6/19	Date:	

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

10.04.15



103228 MJS
1306-F

D4712-3 BRACKET

NOTES:

- 1) MATERIAL: MAKE FROM D4712-3F FLAT PATTERN
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.11 lbs

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	RF	DRAWING NO.	REV. A
MFG. APPR.	RF	D4712	SHEET 5 OF 8
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	SUPPORT BRACKET ASSY	NTS
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RELEASED
2012-11-05

RELEASED
2012-11-05

1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC M6061T6S.050

- 2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.11 lbs

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DRAWN	RF		SHEET 6 OF 8
CHECKED	RF		SCALE
MFG. APPR.	RF		NTS
APPROVED	RF		
DE APPR.	RF		
DATE	12.07.25		